



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2938-2BL
Job Sheet 186106



Part No: D2938-2BL

Job Qty: 3 ea

Part Name: Saddle RH Out, 206



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/9/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Machining-1		SBL 18/11/20
100	CNC Vertical Machining	3 pcs	12/14/18	12/14/18	0.35	4.57	HAAS1-2		SBL 18/11/20
110	Mill Conv	3 pcs	12/14/18	12/14/18	0.00	4.57	Mill Conv 1		SBL 18/11/20
120	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC1		SBL 18/11/20
130	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC8 Machining-1		DR 18/11/21
140	HandFinish	3 pcs	12/14/18	12/14/18	0.00	0.25	HandFinish1		DR 18/11/21
150	Outsource	3 pcs	12/14/18	12/14/18			ATE003-VC		DR 18/11/21
155	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging2		DEC 03 2018
160	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC14		38
170	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-1		DEC 06 2018
180	QC21-SA	3 Ea	12/14/18	12/14/18	0.00	0.00	QC21		6

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO 041880

DAS 9-89
21
9-89 DEC 06 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	3 Ea (1 ea)	90-Start up Operation	5038654 5129305

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-003	3	63	0

Part Specifications

Specifications could not be found.



Work Order update only

Work Order:		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																																		
Part No.				Engineering Quality Other																																																																		
NCR No.				Water Jet Prod. Eng. Coord. Proc./Packaging Supplier																																																																		
Date :				MRB (QSI042) Approval																																																																		
Description				Completed By																																																																		
				Lead hand / Supervisor Approval Verification																																																																		
				QC / QA Coordinator Approval																																																																		
Root Cause <table border="1"><tr><td>Environment</td><td>No Re-verification</td><td>Pressure/Forced</td><td>Temperature/Cure</td><td>Power Loss/Surge</td><td>Positioned Wrong</td></tr><tr><td>Design</td><td>Operator</td><td>Bending</td><td>Set-up</td><td>Folio/Program</td><td>Outside Dimensions</td></tr><tr><td>Doc/Data</td><td>Offset/Setups</td><td>Centre Not Concentric</td><td>BOM/Route</td><td>Grain</td><td>Over/Under tolerance</td></tr><tr><td>Equip/Tooling</td><td>Supplier</td><td>Cracks</td><td>Broken/Damage/Defect</td><td>Weld</td><td>Part Incorrect</td></tr><tr><td>Handling/Pre</td><td>Training</td><td>Crimp/Kink/Ripple/Wave</td><td>Inspection Incomplete/Unqualified</td><td>Wrong Stock Pulled</td><td>Part Lost/Missing</td></tr><tr><td>Material</td><td>Use for Testing</td><td>Cuffs</td><td>Contamination</td><td>Out of Sequence</td><td>Part Moved</td></tr><tr><td>Internal Transport</td><td>Poor Information</td><td>Crushing</td><td>Countersink</td><td>Off-set</td><td>Drawing</td></tr><tr><td>Tribal Knowledge</td><td>Rushing</td><td>Heat Treat</td><td>Cut Too Short</td><td>Mislabeled</td><td>Finish</td></tr><tr><td>LOA</td><td>Product Improvement</td><td>Wave/Twist in Tube</td><td>Instructions Incomplete/Unclear</td><td>Fit/Function</td><td>Misread</td></tr><tr><td>Substation</td><td>Process Improvement</td><td>Marks/Chatter</td><td>Drill Holes</td><td>Misaligned/off center</td><td>Turning Sequence</td></tr></table>								Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong	Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions	Doc/Data	Offset/Setups	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect	Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing	Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved	Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing	Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish	LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread	Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence	FAULT CATEGORY <table border="1"><tr><td>OTHER :</td></tr></table>		OTHER :
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OTHER :																																																																						

Part: D2938 - 2BL

Job No: 186106

Serial No/Batch: S129306

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/20/18

Container No: S129306

Dart Aerospace Ltd.
1270 Aberdeen Street,
Hawthornbury, ON K8A 1K7
CANADA
TEL: 1 613 692 - 5200
Email: sales@dart aero.com
www.dartaerospace.com

DART AEROSPACE LTD	Work Order: 186106
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.114	.114	.114			
B	0.100	0.140		.115	.114	.114			
C	0.100	0.140		.115	.115	.113			
D	0.210	0.230		.223	.224	.224			
E	1.245	1.255		1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.500	.500	.502			
I	1.572	1.582		1.577	1.577	1.577			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		.257	.257	.257			
L	0.312	0.317		.312	.313	.313			
M	0.235	0.240		.239	.239	.239			
N	0.100	0.140		.120	.121	.121			
O	0.540	0.560		.548	.549	.547			
P	0.490	0.510		.510	.510	.510			
Q	3.715	3.725		3.720	3.720	3.720			
R	2.720	2.760		2.745	2.745	2.745			
S	0.240	0.270		.255	.255	.255			
T	0.100	0.180		.135	.134	.136			
U	1.625	1.635		1.630	1.630	1.630			
V	1.362	1.372		1.367	1.367	1.367			
W	0.316	0.321		.316	.316	.316			
X	1.250	1.270		1.260	1.260	1.260			
Y	1.565	1.585		1.575	1.575	1.575			
Z	0.178	0.198		.188	.188	.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: DAS	Audited by: <i>[Signature]</i>
Date: 57 18/11/20	Date: 18/11/21
9-89	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041880**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041880
PO Date: 11/28/18
Due Date:
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186184	D4308-042BL	Step, RH Crew : Various STC's As per Dwg D4308 Rev A Prime and Spray Paint Delfleet Blue	Firmed	-		6 pcs	0 pcs	6 pcs	\$40.00/pcs	\$240.00
2	186170	D2646BL	Aft Cap : Various STC's	Firmed	-		6 pcs	0 pcs	6 pcs	\$21.00/pcs	\$126.00
3	186109	D3413-1BL	O-Ring : Various STC's SPRAY PAINT BLUE BATCH: _____	Firmed	-		10 pcs	0 pcs	10 pcs	\$15.00/pcs	\$150.00
4	186107	D2939-1BL	Saddle LH In, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
5	186101	D2932-1BL	Saddle LH Out, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** BATCH: _____	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
6	186103	D2933-1BL	Saddle LH In, 206 : Various STC's *** MASK ALL HOLES AS PER PAR16-484*** BATCH: _____ ISSUE PO	Firmed	-		4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
7	186106	D2938-2BL	Saddle RH Out, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	-		3 pcs	0 pcs	3 pcs	\$25.00/pcs	\$75.00



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PURCHASE ORDER **PO041880**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	186105	D2938-1BL	Saddle LH Out, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	-	4 X DEC 03 2018	4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
9	186102	D2932-2BL	Saddle RH Out, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** SPRAY PAINT BLEU	Firmed	-	3 X DEC 03 2018	3 pcs	0 pcs	3 pcs	\$25.00/pcs	\$75.00
10	186108	D2939-2BL	Saddle RH In, 206 : Various STC's ** MASK ALL HOLES AS PER PAR16-484***	Firmed	-	3 X DEC 03 2018	3 pcs	0 pcs	3 pcs	\$25.00/pcs	\$75.00
Grand Total:											\$1,141.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/28/18 1:16 PM dart.tsimiklis.chrisoula

